

Work Order ID 69873

Tuesday, May 24, 2011 8:25:18 AM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Skidtube LH

Start Date: 5/24/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/30/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3492

C

IIN-D350-636

H

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

5/16/27

for CL 11-6-27

69873

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB 11/06/01

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: M117456

BE 4/06/02

12-Grind welds flush as per Dwg D2750

JB 4/06/03

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 4/06/03

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 4/06/03

Memo

0.00

ⓧ

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							OL 11/06/06
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							1 0 BB 11/06/06

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ ☐ ☐ Sikaflex-291 batch: 116945 ☐ ☐ ☐
exp. date: 12/01/15

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R ☐ ☐ ☐ Aluminum Rod batch: M117456

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

BB 11/06/06

BB 11/06/09
BB 11/06/09
BB 11/06/10

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

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11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

BB

11/06/10

12-Deburr holes

BB

11/06/10

170

QC10- Inspect visual per QS1004- ground welds

0.00



QC

Memo

0.00

Subloc/13

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Subloc/13

70

Quality Control

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							
	HandFinish	0.00				1	0	20	11/06/15
Hand Finishing	<p>Memo</p> <p>✓ Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.</p>								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
	Powdercoat	0.00							
Powder Coating	<p>Memo</p> <p>START TIME: 2:00</p> <p>OVEN TEMPERATURE: 320 °F</p> <p>FINISH TIME: 2:30</p>								1X 0 M-L 11/06/15
210	QC3- Inspect Part Finish	0.00							
	QC	0.00				1			BL 11-6-23
Quality Control	<p>Memo</p> <p>Inspect for foreign object per QSI 024</p>								

AA116964

W/O:		WORK ORDER CHANGES					
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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220		0.00							
	HandFinishing								
HandFinish	Memo	0.00				1		BL 11-623.	
Hand Finishing	1- Install inserts as per Dwg D2750								
230		0.00							
	HandFinishing								
HandFinish	Memo	0.00				1		BL 11-6-23.	
Hand Finishing	1-Inspect for Foreign Objects								
	2-Spray inside of tube with "LPS-3" batch: _____								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 117516 EXP DATE: 15-4								
	4-assemble o'ring to plug as per dwg D2492 and apply o'ring lube A/R 55-o'ring lube batch: 114189								
	5-Coat all exposed fasteners with "LPS Procyon" batch: 114596								

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-011								
	<i>I</i>								
280		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

*Run/27 (1)**11/6/28*
umf
11-06-27

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

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Parent Item: D350-636-011

Parent Item Name: Skidtube LH



Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ
 IPP Rev: J 06-03-23 As per Rev D JLM
 IPP Rev: K 06-07.13 As per dsi9343 EC
 IPP Rev: L 07-07-28 Added SS Wearplates(Rev E) JLM Verf: EC
 IPP Rev: M 08-04-22 update steps 4, 13 DD verified by: EC
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec
 IPP Rev: O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf: EC IPP Rev: P 10.06.22 revise
 seq110 DD verf: EC IPP Rev: Q 10.10.01 as per IIN revH
 DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2594-3 		Manufactured	No	Location	Location	230	Each	1,020.000	8	8			
O-Ring, 205 Skidtube				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				FP-A	1020								
				65518	70								
				66952	950								
D3492-1 		Manufactured	No			230	Each	0.0000	8	8			
Plug				69819									
D3492-3 		Manufactured	No			230	Each	0.0000	8	8			
Plug				698752 698722									

8. BL 11-6-23.
 8. BL 11-6-23

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Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

266.0000

8

8



O-RING

Location

Loc Qty

Loc Code

FP 80
117460 80
FP-A 186
110915 139
115589 ✓ 47

250

Each

43.0000

2

2

AN960JD816

Purchased

No



1/2" washer, Alum

Location

Loc Qty

Loc Code

FP-A 43
106043 43

110

Each

26.0000

1

1

D2744

Manufactured

No



Cap

Location

Loc Qty

Loc Code

LG002 26
62715 2
65086 24

110

Each

14.0000

1

1

D2600-3-BENT

Manufactured

No



Extrusion Bent

Location

Loc Qty

Loc Code

LG 14
66875 8
68137 6

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Shop Packet Print

Page 2

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Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2743

Manufactured No

160 Each

162.0000 8 8



Crossbolt Spacer



BE 11/06/09

Location Loc Qty Loc Code

LG	63	
68948	63	
LG001	99	
67766	35	
68251	64	

6
2
1

D2739

Manufactured No

160 Each

4.0000 1 1



350 I Beam



69538

Location Loc Qty Loc Code

LG	4	
67785	1	
68285	3	

1

BE 11/06/06

D3490-3

Manufactured No

160 Each

86.0000 4 4



Cross Bolt Spacer



BE 11/06/09

Location Loc Qty Loc Code

LG	86	
68106	22	
68952	64	

4

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Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3490-1 Manufactured No

160

Each

49.0000

4

4



Cross Bolt Spacer



BE 11/06/09
B 69510 x2

Location

Loc Qty

Loc Code

LG

47

67773

5

68105

42

LG001

2

62450

2

ALS4-1032-225 Purchased No

220

Each

1,617.000

38

38



Insert



Location

Loc Qty

Loc Code

ST282

1617

110768

817

117717 ✓

800

D3793-3 Manufactured No

230

Each

30.0000

1

1



Wearshoe



38. BL 11-6-23.

Location

Loc Qty

Loc Code

FP018

21

68356 ✓

13

69283

8

FP019

9

64447

9

1 BL 11-6-23.

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:25 AM

Page 5

Work Order ID: 69873

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

69.0000

1

1



BOLT



Location

Loc Qty

Loc Code

FP

40

117511

40

FP-A

29

115960

6

116874 ✓

23

D3793-1

Manufactured

No

230

Each

31.0000

1

1



Wearshoe



Location

Loc Qty

Loc Code

FP018

31

64445 ✓

14

69285 ✓

17

D3488-041

Manufactured

No

230

Each

21.0000

1

1



Blade Fitting Assembly, LH



Location

Loc Qty

Loc Code

FP007

1

61689

1

FP008

20

62002

2

67788

6

68108 ✓

12

1 BL 11-6-23

1 BL 11-6-23

1 BL 11-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:26 AM

Page 6

Work Order ID: 69873

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-3

Manufactured No

230 Each

34.0000

1 1



Gasket



BR 11-6-23

Location

Loc Qty

Loc Code

FP010

26

68357 ✓

26

FP018

8

39422

1

61712

7

1

AN6C44A

Purchased No

230 Each

113.0000

4 4



BOLT



BR 11-6-23

Location

Loc Qty

Loc Code

FG

2

103964

2

ST344

111

117407 ✓

80

117763

31

4

MS21083C8

Purchased No

230 Each

113.0000

1 1



NUT



BR 11-6-23

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

112

115884

0

117291

37

117423 ✓

50

117677

25

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:26 AM

Page 7

Work Order ID: 69873

Parent Item: D350-636-011



Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011



Start Qty: 1.00

Required Qty: 1.00

D3536-25	Manufactured	No	230	Each	34.0000	1	1
							
Gasket							<i>BR 11-6-23.</i>



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP012	34	
65903	8	
68351	26	

D3631-1	Manufactured	No	230	Each	500.0000	8	8
							
Washer							



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------



ST072	500	
68062	500	

D3791-1	Manufactured	No	230	Each	19.0000	1	1
							
Wearplate							<i>BR 11-6-23.</i>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP017	19	
62239	7	
68352	12	

AN960C10L	NAS1149C0332R	Purchased	No	230	Each	0.0000	38	38
								
washer							<i>BR 11-6-23.</i>	

D2745	Manufactured	No	230	Each	206.0000	8	8
							
Bushing							<i>BR 11-6-23.</i>

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP-A	206	
67764	5	
68248	201	

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:26 AM

Page 8

Work Order ID: 69873

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C5A
Bolt

Purchased No

230 Each

1,586.000

34

34



BL 11-6-23

Location

Loc Qty

Loc Code

FP-A

7

115835

7

ST350

1579

115422

49

116419

334

116549

96

117343

500

117508

300

117764

300

34

D3537-1
Wearpad

Manufactured No

230 Each

34.0000

3

3



BL 11-6-23

Location

Loc Qty

Loc Code

FP017

34

63313

2

66804

28

66935

4

3

AN960C816L

Purchased No

230

Each

0.0000

1

1



1

BL 11-6-23

WASHER

NAS1149C0832R 114915

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:27 AM

Page 9

Work Order ID: 69873

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C6A


Purchased No 230 Each 410.0000 4 4

BOLT



BL 11-6-23.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP-A	1	
111982	1	
ST351	409	
111982	2	
116419	23	
116549	50	
116704	84	
117514 ✓	100	4
117619	50	
117688	100	

NAS1611-013


Purchased No 230 Each 168.0000 8 8

O-RING



BL 11-6-23.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	163	
117291 ✓	123	8.
117460	40	
FP-A	5	
116582	5	

D3535-25


Manufactured No 230 Each 30.0000 1 1

Wearshoe



BL 11-6-23.

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP018	30	
62233	1	
65167	3	
68353 ✓	11	
69284 ✓	15	1

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Shop Packet Print

Page 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:27 AM

Page 10

Work Order ID: 69873

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D3794-1

Manufactured No

230 Each

32.0000

1 1



Gasket



BR 11-6-23

Location

Loc Qty

Loc Code

FP010

32

39421

1

61704

5

68355 ✓

26

MS21043-6

Purchased No

230 Each

523.0000

4 4



BR 11-6-23

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

FP-A

40

112314 ✓

40

ST301

463

112314

463

D3493-1

Manufactured No

250 Each

72.0000

2 2



CR 11/6/23

Washer

Location

Loc Qty

Loc Code

ST062

72

66975

31

68253

41

68253

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:27 AM

Page 11

Work Order ID: 69873

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

250 Each

113.0000

2

2



NUT

Location

Loc Qty

Loc Code

FP-B

1

115884

1

ST303

112

115884

0

117291

37

117423

50

117677

25

117677

AN8C21A

Purchased No

250 Each

101.0000

2

2



BOLT

Location

Loc Qty

Loc Code

ST344

25

117764

25

ST345

76

116381

26

117562

50

117562

NAS1515H3L

Purchased No

230 Each

276.0000

8

8



WASHER

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

236

113362 ✓

236

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, May 24, 2011 8:25:27 AM

Page 12

Work Order ID: 69873

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 5/24/2011

Required Date: 5/30/2011

Start Qty: 1.00

Required Qty: 1.00

D2741

Manufactured No

250 Each

44.0000

1

1



Blade, 350 Skidtube



[Signature]

Location

Loc Qty

Loc Code

ST466

44

61341

6

63589

38

D3532-1

Manufactured No

250 Each

35.0000

2



Spacer



63589

21

[Signature] 271

Location

Loc Qty

Loc Code

ST065

35

62218

13

66949

22

66949

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

4

3

2

1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69778

11-05-24

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H3L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	PA		
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 1 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

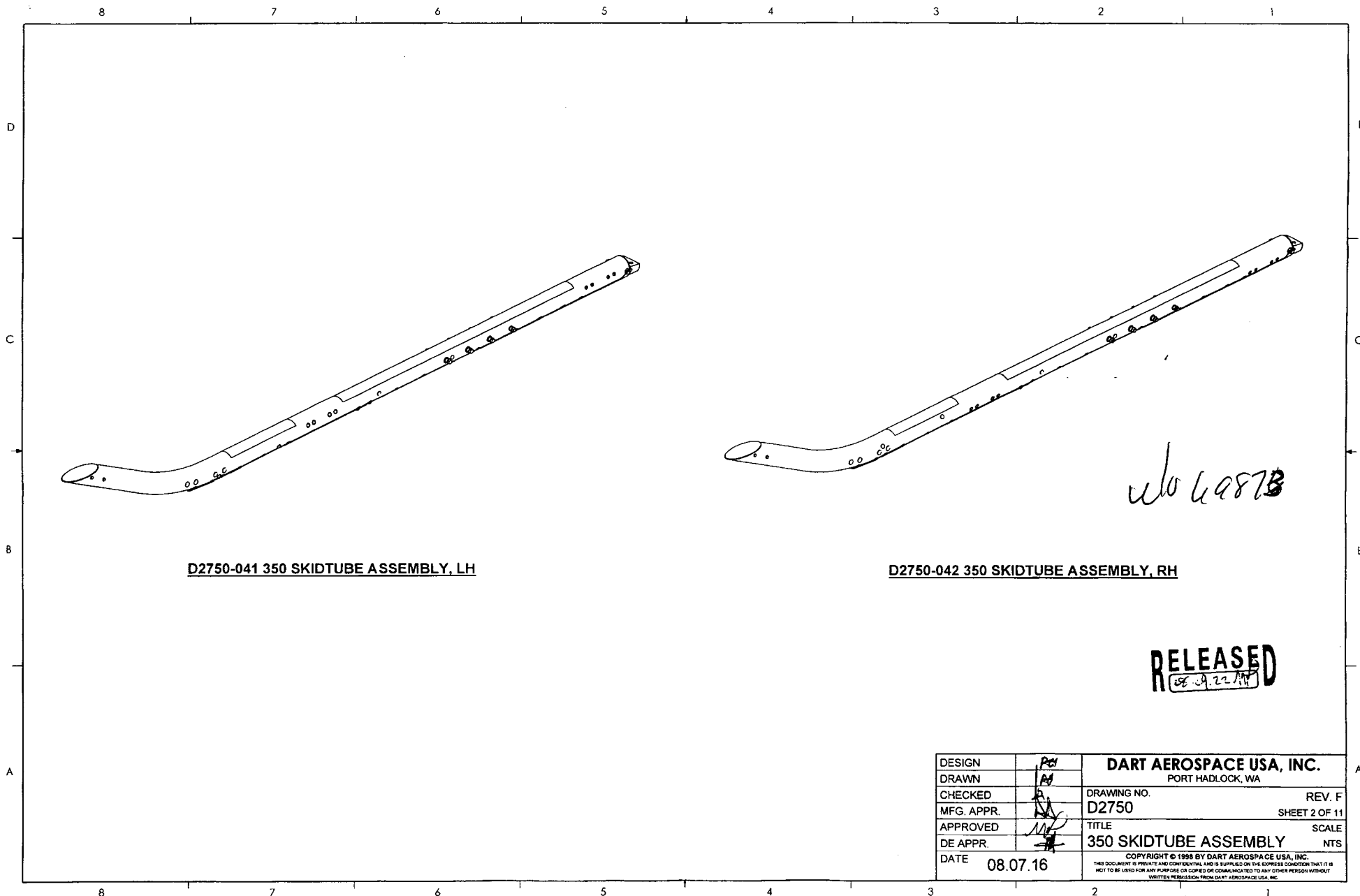
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



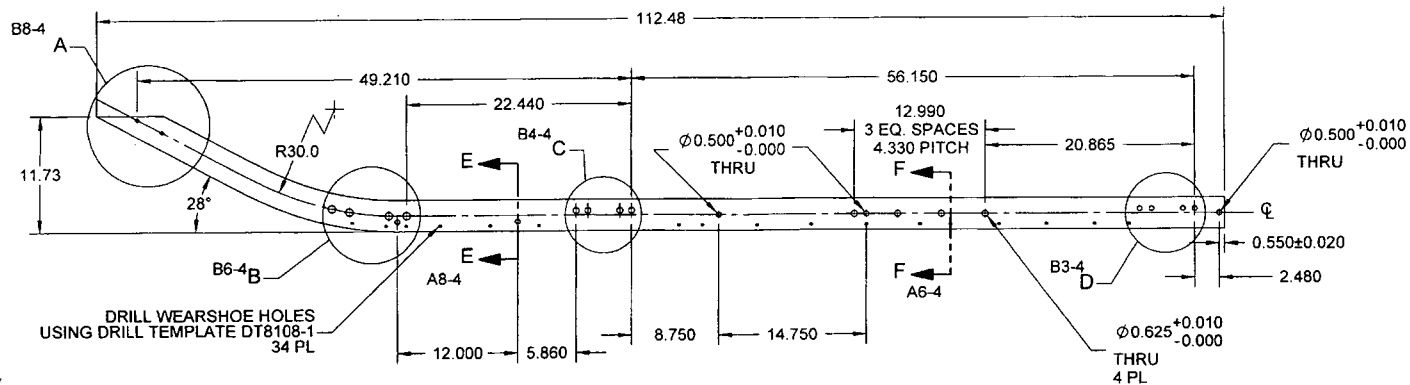
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

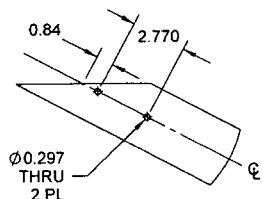
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

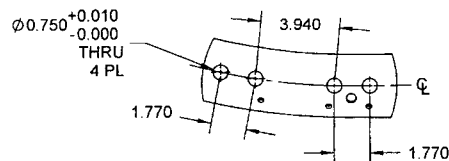
NOTE: Date & initial all entries



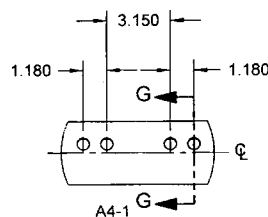
D2750-1 LH SKIDTUBE



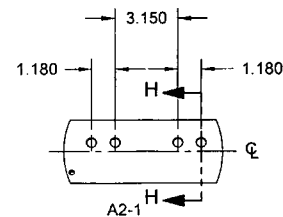
DETAIL A
SCALE 2X



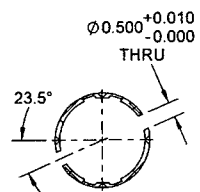
DETAIL B
SCALE 2X



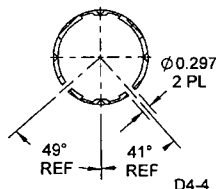
DETAIL C
SCALE 2X



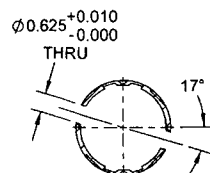
DETAIL D
SCALE 2X



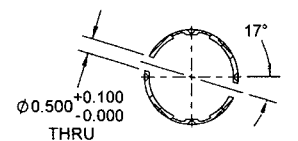
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

RELEASED

DESIGN	IPB	DART AEROSPACE USA, INC.	
DRAWN	IPB	PORT HADLOCK, WA	
CHECKED	IPB	DRAWING NO. D2750	REV. F
MFG. APPR.	IPB	SHEET 4 OF 11	
APPROVED	IPB	TITLE	SCALE
DE APPR.	IPB	350 SKIDTUBE ASSEMBLY	
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

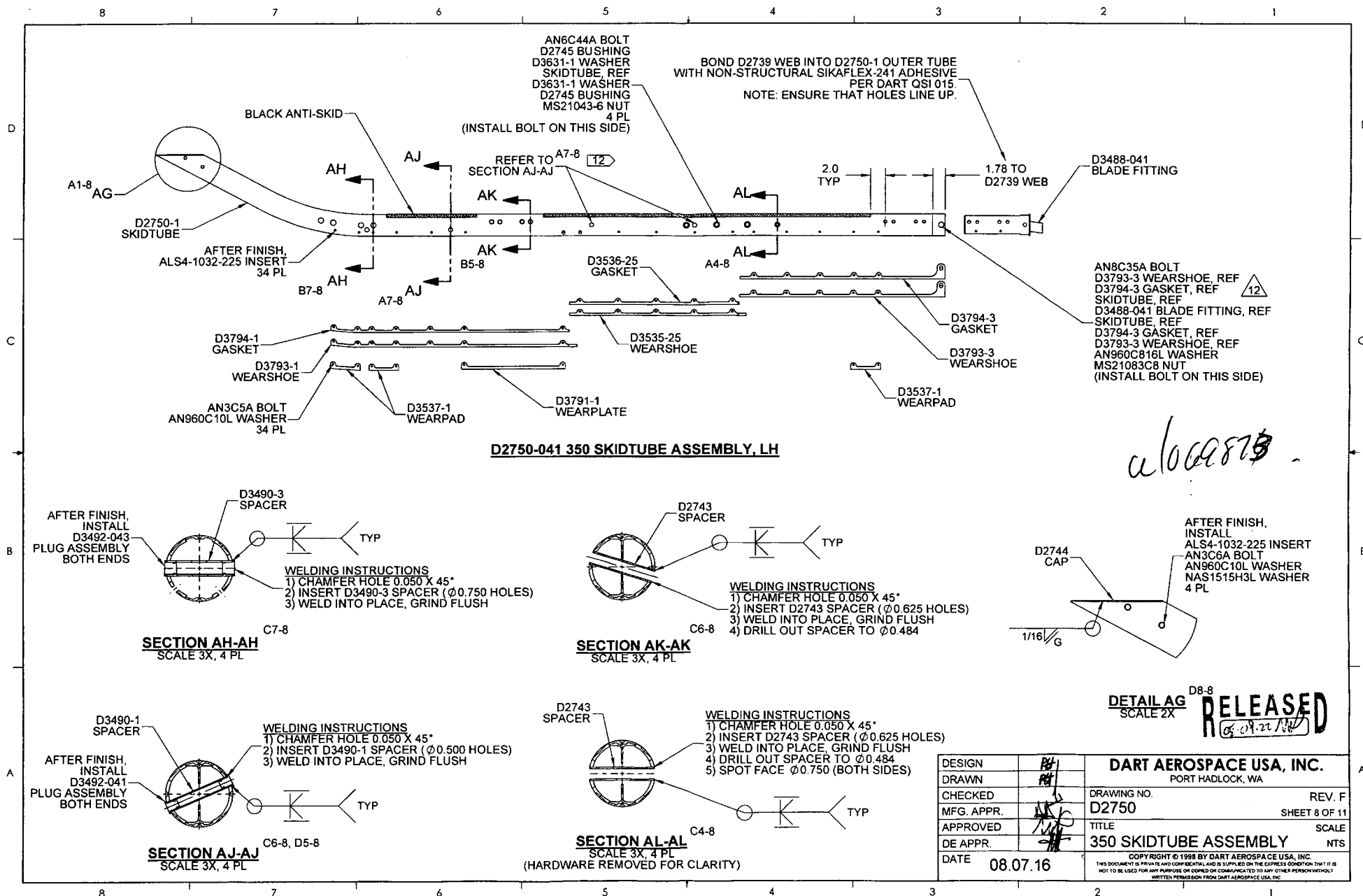
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 254

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 69872
Part number: 350 636 011
Description: 350
Welding Process: Tig ☒ Mig ☐
Base material: aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Pat Lewis Date of Test Coupon 11.06.08
Welder Barclay Elliot Date of Test Coupon 11/06/08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

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